

Work Order ID 145030

Friday, April 29, 2016 1:15:04 PM

145030

Page 1

Item ID: D3564-9 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Fwd
 Start Date: 5/16/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 5/26/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Em Date: 16/04/29 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3564	E2								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo <u>From - 1F</u>	1.20							
FLOW CNC Waterjet	1-Cut as per Dwg D3564 Dwg Rev: <u>D</u>								
	Prog Rev: <u>D</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.06							
Quality Control									

⑥

02/16/05/18

⑥

02/16/05/18

Friday, April 29, 2016 1:15:04 PM

Page 2

Reference:

Run	Start	*NR1*
	Stop	*NR2*

[illegible]

Work Order ID 145030

Friday, April 29, 2016 1:15:04 PM

145030

Page 3

Item ID: D3564-9

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Fwd

Start Date: 5/16/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/26/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

150

Large Fab

Large Fab

Memo

0.00

Large Fab

1- WELD AS PER DWG AND QSI004

2059B HARDCOAT BATCH: 11/30/145

160

160

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

(6)

1605-24

DAS
9
9-89

170

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.12

(6)

1605-24

DAS
9
9-89

Work Order ID 145030

Friday, April 29, 2016 1:15:04 PM

145030

Page 4

Item ID: D3564-9

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Fwd

Start Date: 5/16/2016 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/26/2016 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3

0.00

180

Powdercoat

Powder Coating

M 130746

Memo

START TIME:

8:55

0.12

OVEN TEMPERATURE:

300°

FINISH TIME:

9:25

6 16-05-28 2348

190

QC3- Inspect Part Finish

0.00

190

QC

Quality Control

Memo

0.06

⑥

DAS
38
9-89

MAY 30 2016

200

Identify as per dwg & Stock Location: FP-002

0.00

200

Packaging

Packaging

Memo

LOCATION : FP002

0.06

x6 f Plu 05/30

Friday, April 29, 2016 1:15:04 PM

Page 5

MC MAY 30 2016

Picklist Print

Friday, April 29, 2016 1:15:15 PM

Page 1

Work Order ID: 145030

145030

Parent Item: D3564-9

D3564-9

Parent Item Name: Wearplate Fwd

Start Date: 5/16/2016

Required Date: 5/26/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No		100	sf	254.3600	1.41	8.905263			

M304S16GA

304/316 Sheet .063

04/16/05/18

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT010	80	
m134677	80	
MAT019	82.276	
m134067	0.706	
m134158	17.303	
m134399	1.067	
m134551	63.2	6.5
TPI	92.084	
m134604	92.084	

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework Scrap Use-as-is Suspected Unapproved		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due		FAULT CATEGORY Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence							
		OTHER :							

DART AEROSPACE LTD		Work Order:	145030
Description: Wearshoe		Part Number:	D3564-9
Inspection Dwg: D3564 Rev: D		Page 1 of 1	

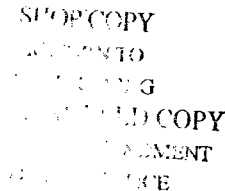
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.223	✓			
2.432	+/-0.010	2.440	✓			
2.50	+/-0.030	2.50	✓			
6.000	+/-0.010	6.003	✓			
12.104	+/-0.010	12.104	✓			
18.000	+/-0.010	18.000	✓			
18.000	+/-0.010	18.000	✓			
18.00	+/-0.030	18.000	✓			
9.00	+/-0.030	9.00	✓			
11.50	+/-0.030	11.510	✓			
0.300 x 0.300	+/-0.010	0.300 x 0.300	✓			
Ø0.188	+0.005/-0.001	0.188	✓			
R0.375	+/-0.010	0.375	✓			
0.063	+/-0.010	0.060	✓			

Measured by: PR / a	Audited by: DAS 38	Prototype Approval:	N/A
Date: 16/05/18	Date: MAY 18 2016	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.01.16	New Issue	KJ/EC/DD	



145030 MC=

RELEASED

07.09.04

8.50
ON FLAT

R50.0

30.50

C

C

DETAIL B

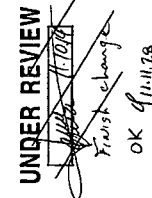
SEE DETAIL D
FOR WELDING

DETAIL B

D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)

D

D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



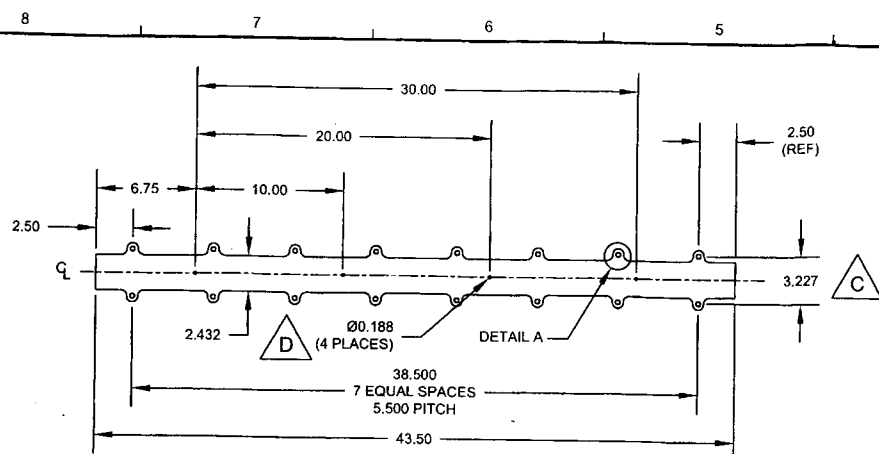
D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: SEE TABLE IN ZONE A3
8) WELD PER DART QSI 004
9) SEE PG 3 FOR SECTIONS AND DETAILS
10) PARTS ARE SYMMETRIC ABOUT C

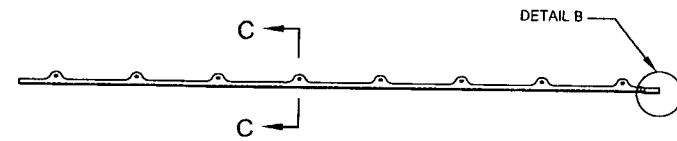
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5, C5: ADD D3564-15; PG1 B6, B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8, C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5, 7, B2: RELOCATE DETAILS AND SECTION; PG3 A5, 7, B2: INCREASE DETAIL AND SECTION SIZE		CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A		PH	07.04.17
B	ADD AMS 5513 AND AMS 5524		PH	07.03.20
A	NEW ISSUE		PH	06.12.18
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	CB			
CHECKED	PH	DRAWING NO.	REV. D	
MFG. APPR.	PH	D3564	SHEET 1 OF 3	
APPROVED	PH	TITLE	SCALE	
DE APPR.	PH	WEARSHOE	1:	
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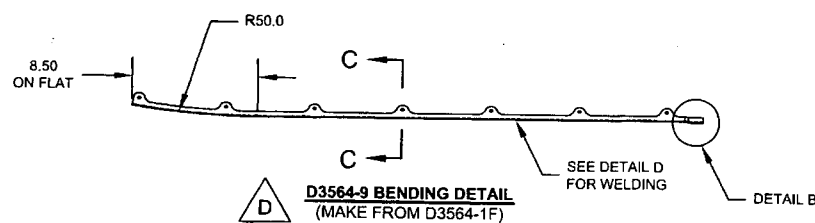
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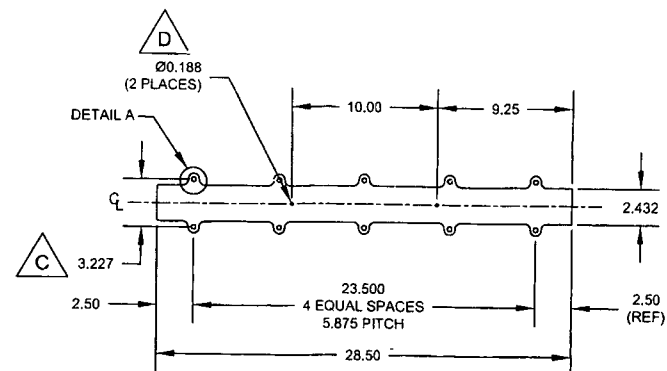
D3564-5F FLAT PATTERN



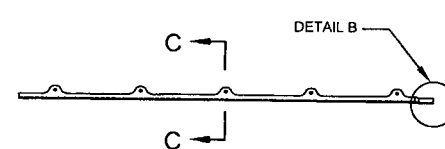
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



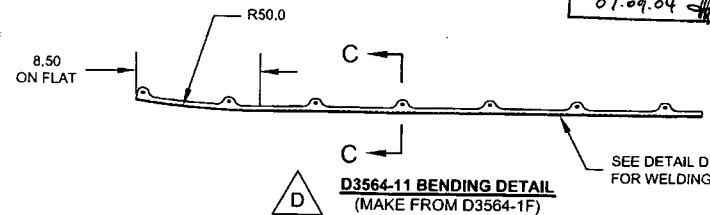
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



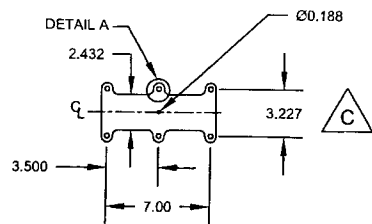
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

UNDER REVIEW
OK 07.11.28

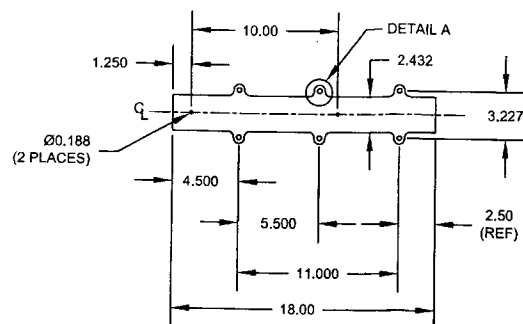
RELEASED
07.09.04

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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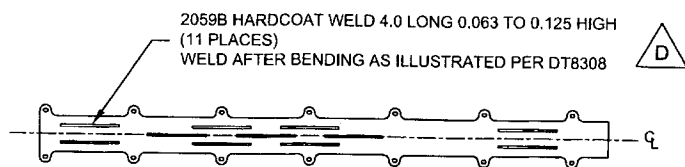
8 7 6 5 4 3 2 1



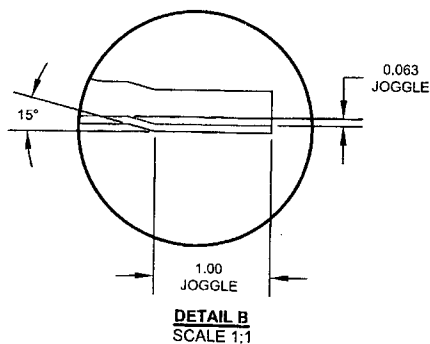
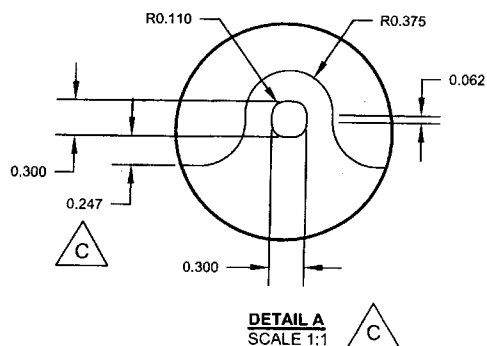
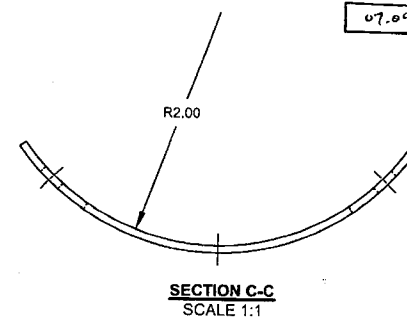
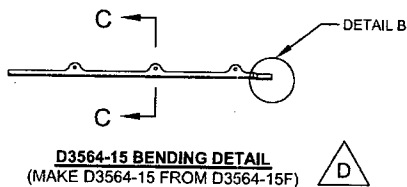
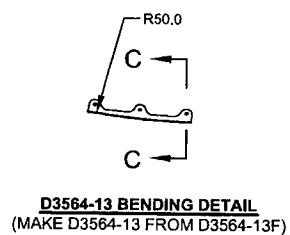
D3564-13F FLAT PATTERN



D3564-15F FLAT PATTERN



DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
APPROVED	PH	TITLE	SCALE
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07.09.04

UNDER REVIEW
OK 07.11.28